

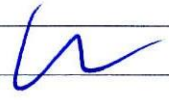
Work Order ID 150675

Monday, August 29, 2016 2:59:01 PM

150675

Page 1

Item ID: D3631-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Washer
Start Date: 8/22/2016 Start Qty: 100.00 ***100*** Cust Item ID:
Required Date: 8/29/2016 Req'd Qty: 100.00 ***100*** Customer:
Reference:

Approvals: Process Plan:  Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3631	Rev A								
100	PURCHASING	0.00							
100									
Purchasing	Memo	0.00							
Purchasing	Issue P/O: <u>33481</u> Purchase Part Number: 95606A170 Supplier: Mc								
	Master CarrCertificate of conformity is required								
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110									
Packaging	Memo	0.33							
Packaging	Ensure certificate of conformity is attached								
120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	Memo	0.00							
Quality Control									

100 AUG 30 2016 DAS 13
100x 50/6-9-6
100 DAS 38 9-89
SEP 07 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process								
Misidentified ☐	☐ Past Due	OTHER :							

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DAS
21
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
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Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER :						
Misidentified ☐	☐	Past Due ☐							

Picklist Print

Monday, August 29, 2016 2:59:00 PM

Page 1

Work Order ID: 150675

150675

Parent Item: D3631-1

D3631-1

Parent Item Name: Washer

Start Date: 8/22/2016

Required Date: 8/29/2016

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP Rev:A New Issue 07-07-28 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

95606A170

Purchased

No

110

Each

0.0000

1

100

95606A170

Washer

100x sp/16 9-6.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

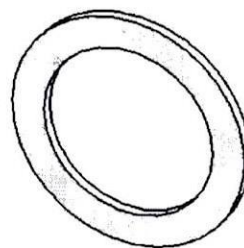
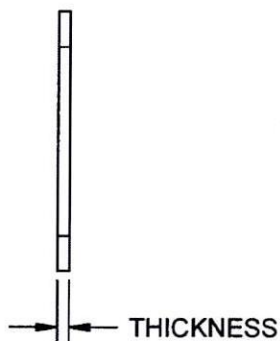
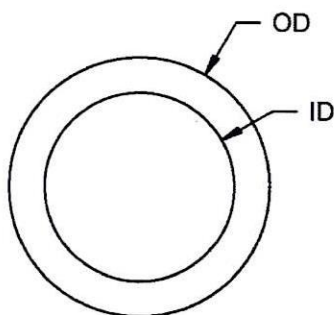
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
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OTHER : _____																									



DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D3631	REV. A SHEET 1 OF 1
DATE 07.05.16		TITLE WASHER	SCALE NTS
REV A	DATE 07.05.16	DESCRIPTION NEW ISSUE	

SPECIFICATION CONTROL DRAWING



4/10/150675

D3631-X WASHER

RELEASED
07.08.02 **[Signature]**

PART NUMBER	OD	ID	THICKNESS	MATERIAL	SUPPLIER
D3631-1	0.688	0.500	0.031	NYLON	McMASTER-CARR P/N: 95606A170

NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO33481**

Purchase Order Date 8/30/2016

PO Print Date 8/30/2016

Page Number 3 of 6

Order From :

MCMASTER-CARR SUPPLY CO,
P.O. BOX 7690
CHICAGO, IL 60680-7690
US

VU-MCM001

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 330 995 5500

Ship To Contact

Ship To Phone

Ship Via: Purolator ground ppd

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 10

Currency

USD

FOB

FCA - (Free Carrier)

6	6718K52	Fitting, Quick Disconnect	9/2/2016	4.00	\$5.81	\$23.24
			Yes	Each		
			9/2/2016			

AS PER DWG D4182 REV. B
B150655

Line Total: \$23.24

7	92311A639	SS SET SCREW	9/2/2016	50.00	\$0.63	\$31.45
			Yes	Each		
			9/2/2016			

AS PER DWG D2747 REV. B
B150669

Line Total: \$31.45

8	95606A170	Washer	9/2/2016	100.00	\$0.09	\$8.60
			Yes	Each		
			9/2/2016			

AS PER DWG D3631 REV. A
B150675

Line Total: \$8.60

SP/6-9-6

Note:

8/30/2016



200 Aurora Industrial Pkwy
Aurora OH 44202-8087
330-995-5500
cle.sales@mcmaster.com

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada

Purchase Order
PO33481

Order Placed By
Chantal Lavoie

McMaster-Carr Number
7924498-01

Page 1 of 1

08/30/2016

Line	Product	Ordered	Shipped
2	63215K34 Stainless Steel Ball Joint Swivel Bearing, PTFE Lined, 3/8" ID, 13/16" OD, 13/32" Ball Thick	10 Each	10
3	97395A451 Corrosion Resistant Dowel Pin, Type 316 Stainless Steel, 1/8" Diameter, 3/4" Length, Packs of 10	5 Packs	5
4	6605K56 Hook and Loop Cable Ties, 24" Overall LG. , Meets UL 94V2, Packs of 5	2 Packs	2
5	91525A120 316 Stainless Steel Washer, Oversized, 1/4" Screw Size, 0.281" ID, 1" OD, Packs of 25	2 Packs	2
6	6718K52 303 Stainless Steel Indust-Shape Air Hose Coupling, Plug, 1/4 Coupling Size, 1/4 NPTF Female End	4 Each	4
7	92311A639 18-8 Stainless Steel Cup Point Set Screw, 3/8"-24 Thread, 1" Long, Packs of 10	5 Packs	5
8	95606A170 Nylon Plastic Washer, for 7/16" Screw Size, 0.5" ID, 0.688" OD, Off-White, Packs of 100	1 Pack	1
9	7467A26 3M Adhesive Cartridge, DP460 High Strength Epoxy, 1.25 Ounces	12 Each	12
10	9438K1 Food-Grade Antiseize Lubricant, 1 lbs. Brush-Top Can	1 Each	1
11	6718K88 303 Stainless Steel Indust-Shape Air Hose Coupling, Size 3/8, Sleeve-Lock Socket, 3/8" ID	2 Each	2
12	91251A440 Black-Oxide Alloy Steel Socket Head Cap Screw, 1/4"-28 Thread, 3/4" Length, Packs of 50	1 Pack	1
13	47505A746 Nylon Mesh Sanding Belt for Cleaning, and Polishing, 6" Wide, 48" Long, Medium Grade	3 Each	3
14	4714A732 High Performance Multipurpose Sanding Belt, 80 Grit, 6" Wide, 48" Long	6 Each	6
15	4714A732 High Performance Multipurpose Sanding Belt, 120 Grit, 6" Wide, 48" Long	6 Each	6

846-9-6

Expected to ship

1	3543T77 High-Strength 301 Stainless Steel Sheet, with Certificate, Full Hard, 0.029" Thick, 12" X 36"	2 Each	2 to ship by 09/13
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Notes about your shipment

The U.S. Department of Transportation regulates the shipping of line 9. By purchasing from McMaster-Carr Supply Company, you agree not to transport or permit others to transport purchased items except in accordance with U.S. law and any other applicable laws.

McMaster-Carr Supply Company
200 Aurora Industrial Pkwy
Aurora, OH 44202-8087 USA
Phone: 330-995-5500 Fax: 330-995-9600
E-Mail: cle.sales@mcmaster.com
Employer Identification Number (EIN): 36-1458720

Invoice: 77017772
Purchase Order: PO33481
Release:
McMaster-Carr Number: 7924498-01

ORIGINAL COMMERCIAL
INVOICE
CERTIFICATE OF ORIGIN

Line	Description	Qty & Unit	Unit Price	Extension
6	6718K52 303 Stainless Steel Indust-Shape Air Hose Coupling, Plug, 1/4 Coupling Size, 1/4 NPTF Female End Country of Origin: United States Schedule B #: 848190 ECCN #: 2B999 NLR	4 EA	\$5.81	\$23.24
7	92311A639 18-8 Stainless Steel Cup Point Set Screw, 3/8"-24 Thread, 1" Long, Packs of 10 Country of Origin: Taiwan Schedule B #: 731815 ECCN #: EAR99 NLR	5 PK	\$6.29	\$31.45
8	95606A170 Nylon Plastic Washer, for 7/16" Screw Size, 0.5" ID, 0.688" OD, Off-White, Packs of 100 Country of Origin: United States Schedule B #: 392690 ECCN #: EAR99 NLR	1 PK	\$8.60	\$8.60
9	7467A26 3M Adhesive Cartridge, DP460 High Strength Epoxy, 1.25 Ounces Country of Origin: United States Schedule B #: 350610 ECCN #: EAR99 NLR	12 EA	\$24.96	\$299.52
10	9438K1 Food-Grade Antiseize Lubricant, 1 lbs. Brush-Top Can Country of Origin: United States Schedule B #: 271099 ECCN #: EAR99 NLR	1 EA	\$23.57	\$23.57
11	6718K88 303 Stainless Steel Indust-Shape Air Hose Coupling, Size 3/8, Sleeve-Lock Socket, 3/8" ID Country of Origin: United States Schedule B #: 848120 ECCN #: 2B999 NLR	2 EA	\$45.19	\$90.38
12	91251A440 Black-Oxide Alloy Steel Socket Head Cap Screw, 1/4"-28 Thread, 3/4" Length, Packs of 50 Country of Origin: United States Schedule B #: 731815 ECCN #: EAR99 NLR	1 PK	\$7.69	\$7.69
13	47505A746 Nylon Mesh Sanding Belt for Cleaning, and Polishing, 6" Wide, 48" Long, Medium Grade Country of Origin: United Kingdom Schedule B #: 680530 ECCN #: EAR99 NLR	3 EA	\$60.78	\$182.34
14	4714A732 High Performance Multipurpose Sanding Belt, 80 Grit, 6" Wide, 48" Long Country of Origin: Germany Schedule B #: 680510 ECCN #: EAR99 NLR	6 EA	\$10.96	\$65.76
15	4714A732 High Performance Multipurpose Sanding Belt, 120 Grit, 6" Wide, 48" Long Country of Origin: Germany Schedule B #: 680510 ECCN #: EAR99 NLR	6 EA	\$9.44	\$56.64
NOTE The U.S. Department of Transportation regulates the shipping of line 9. By purchasing from McMaster-Carr Supply Company, you agree not to transport or permit others to transport purchased items except in accordance with U.S. law and any other applicable laws.				

8/16/96